

# Work Order ID 57992

April 21, 2010 10:38:09 AM



Page 1

Item ID: D4039-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Bracket

Start Date: 21/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 2.00



Customer:

Reference:

*[Handwritten signature]*

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4039

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut blank as per file D4039-1\_BLANK

B10-4-26

①

110

0.00



HAAS

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLI FA880 AND DWG

FOLIO REV: AA

DWG REV: A

DEBURR

88 10/04/27

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Page 2

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Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

*JS 10/04/24*

1

*JS*

QC

Memo

0.00

Quality Control

130

*JS 10.04.28* Memo

0.00

0.00

*JS 10/04/28*

1

*JS*

QC

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

*JS 10/04/29*

1

*JS*

HandFinish

Memo

Hand Finishing

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April 21, 2010 10:38:09 AM

Page 3

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Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

M114207

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00



Powdercoat

Memo

START: 8:15am

0.00

Powder Coating

Temp: 3200F

FIN: 8:45am

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging



=> W 10/04/29

1 0

=> m-h 10/04/29 (W)

10-4-29 (PSP)

# Work Order ID 57992

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Page 4

Item ID: D4039-1

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Revision ID:

Stop



Item Name: Fwd Bracket

Start Date: 21/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/30  
MF  
10-4-29

# Picklist Print

April 21, 2010 10:38:09 AM

Work Order ID: 57992



Parent Item: D4039-1



Parent Item Name: Fwd Bracket

Start Date: 21/04/2010

Required Date: 30/04/2010

Comments: lpp Rev:A New Issue 09-12-15 JLM Verified By:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.000X15.00 0		Purchased		No		100	f	6.5000	6.3158			



6061-T6 Bar 1.00 x 15.00



B10-476

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT07

9544

6.5

6.5

B41961

B41961

①

DART AEROSPACE LTD		Work Order: 57992
Description: Bracket		Part Number: 04039 -1
Inspection Dwg: 04039	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

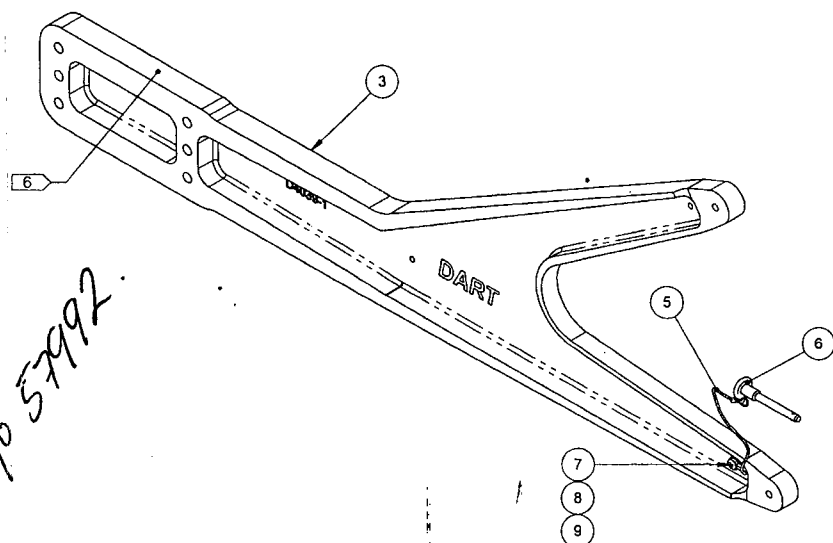
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
19	±.030	136	✓			
4.00	"	4.00	✓			
1.00	"	1.000	✓			
3.73	"	3.734	✓			
.730	+ .010 - .020	.740	✓			
.875	±.010	.872	✓			
6.000	"	5.986	✓			
2.250	"	2.245	✓			
1.125	"	1.120	✓			
.200	"	.200	✓			
.375	"	.373	✓			
1.00	±.030					
.73	"	.740	✓			
<del>Ø.191</del>	<del>±.005 - .001</del>	<del>.193</del>	<del>✓</del>			
Ø.261	+ .006 - .001	.266	✓			
Ø.391	+ .004 - .001	.392	✓			
Ø.203	+ .005 - .001	.205	✓			

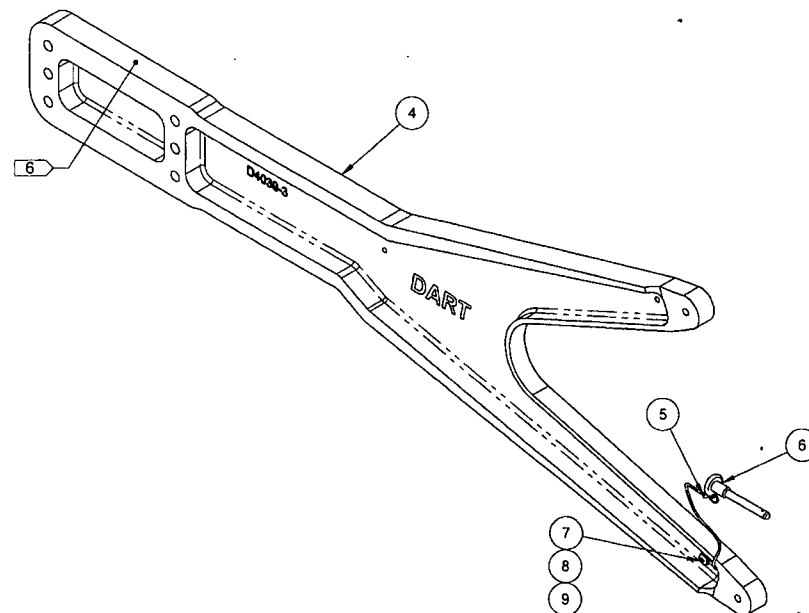
Measured by: <i>SP</i>	Audited by: <i>SP</i>	Prototype Approval:	N/A
Date: 10/04/28	Date: 10/04/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM NO.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D4039-041	FWD BRACKET ASSEMBLY
2		X	D4039-043	AFT BRACKET ASSEMBLY
3	1		D4039-1	FWD BRACKET
4		1	D4039-3	AFT BRACKET
5	1	1	D2690-6	LANYARD
6	1	1	BLRS-010	PIP PIN
7	1	1	MS27039-1-11	SCREW
8	1	1	MS21042L3	NUT
9	3	3	NAS1149D0363J	WASHER



**D4039-041 FWD BRACKET ASSEMBLY**



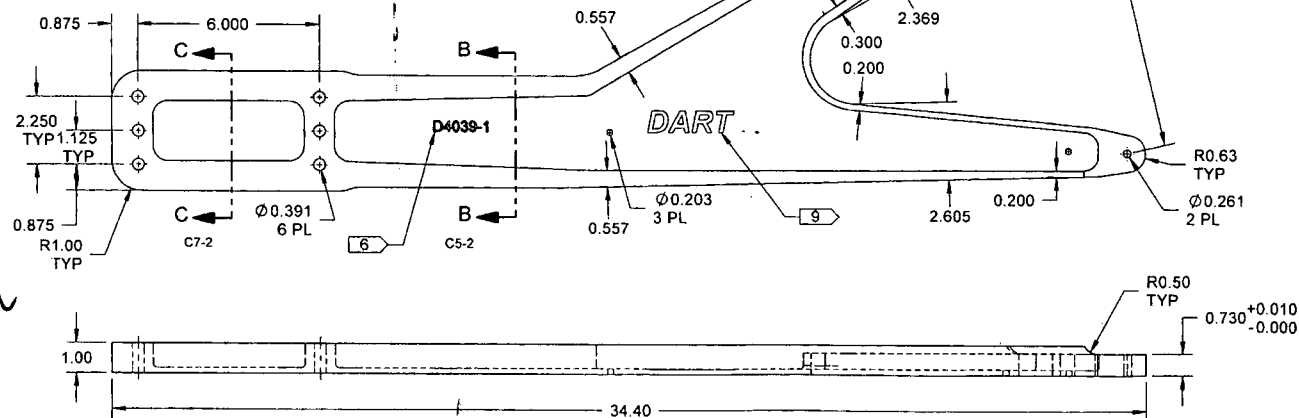
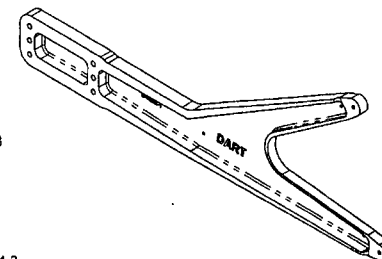
**D4039-043 AFT BRACKET ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4039-041/-043" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A

A	NEW ISSUE	BY	09.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4039	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	09.12.14	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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**RELEASED**  
2010-04-14



### D4039-1 FWD BRACKET

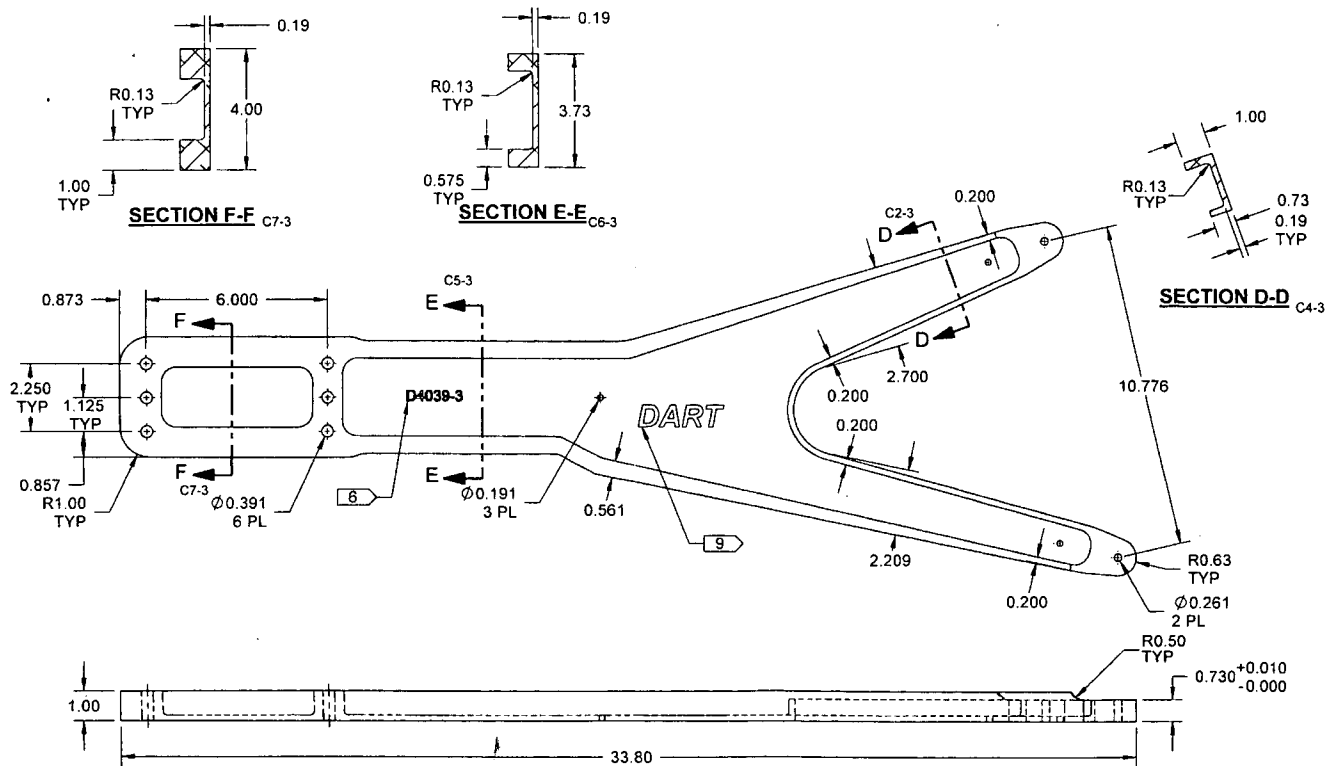
NOTES:

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 1.000 THICK  
PER AMS-QQ-A-250/11 (OR AMS 4025/4027)  
REF DART SPEC M6061T6S1.000
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: ENGRAVE P/N AND BATCH NUMBER IN THIS AREA TO MAX  
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010
  - 7) WEIGHT: 6.64 lbs
  - 8) MACHINE PER DART SOLIDWORKS PART "D4039-1\_REVA.SLDPRT"
  - 9) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250

RELEASE  
2010-04-16  
ms

DESIGN	<del>5</del>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D4039</b>  TITLE <b>BRACKET</b>  COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN CONSENT OF DART AEROSPACE LTD.</small>	REV. A
DRAWN	<del>5</del>		SHEET 2 OF 3
CHECKED	<del>13</del>		SCALE
MFG. APPR.	<del>21</del>		NTS
APPROVED	<del>40</del>		
DE APPR.	<del>4</del>		
DATE	09.12.14		





**D4039-3 FWD BRACKET**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 1.000 THICK  
PER AMS-QQ-A-250/11 (OR AMS 4025/4027)  
REF DART SPEC M6061T6S1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AND BATCH NUMBER IN THIS AREA TO MAX  
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010
- 7) WEIGHT: 6.23 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4039-3 REVA.SLDPRT"
- 9) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250

*w/0 57992*

**RELEASED**  
2010-04-14  
MP

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4039</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>BRACKET</b>	NTS
DATE	09.12.14	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	